

Work Order ID 67882

Monday, April 04, 2011 9:05:28 AM



Ship Apr 15th Page 1

Item ID: D3574-2

Accept



Setup Start



Revision ID:

Item Name: Cabin Floor Protector

Stop



Start Date: 4/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

WJ

Date: 11-04-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3574

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3574 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Debur if necessary

B11-4-4

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-4-4

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Subtotal

10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 67882

Monday, April 04, 2011 9:05:28 AM



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Item ID: D3574-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Floor Protector

Start Date: 4/4/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/5
ME
11-04-05

Picklist Print

Monday, April 04, 2011 9:05:23 AM

Page 1

Work Order ID: 67882



Parent Item: D3574-2



Parent Item Name: Cabin Floor Protector

Start Date: 4/4/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev :A New Issue 07-01-22 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No				sf	2,908.715		33.61681			
GE PLASTICS LEXAN SHEET													



B11-4-4

Location

Loc Qty

Loc Code

MAT018

2908.715789

112585

120

115261

768

116236

2020.71579

112585

(1)

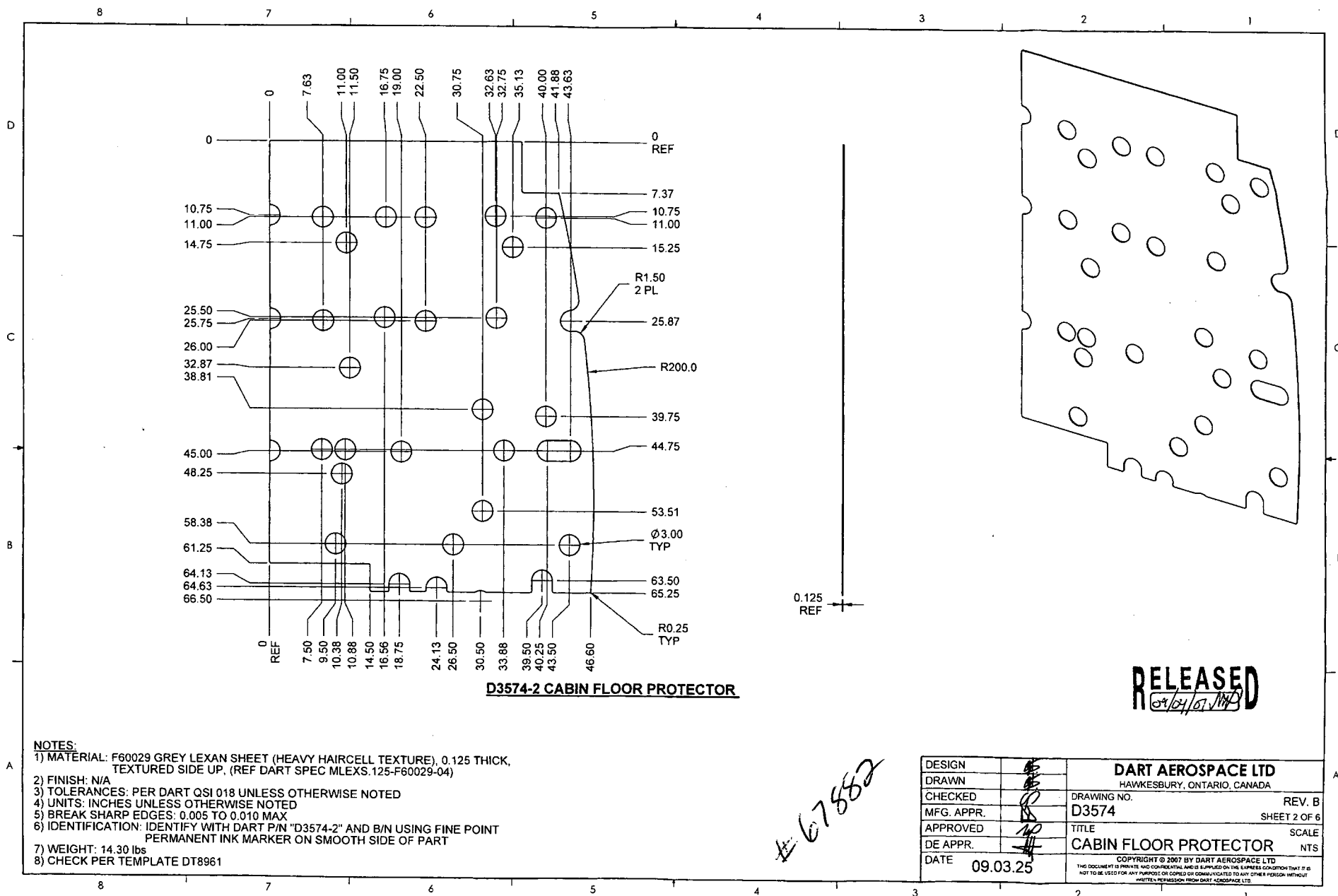
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DART AEROSPACE LTD		Work Order:	67882
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574	Rev: B	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	3.003	X		V 1802	
7.37	+/-0.030	7.37	X		T 1801	
10.75	+/-0.030	10.75	X		T	
11.00	+/-0.030	11.00	X		T	
15.25	+/-0.030	15.25	X		T	
25.87	+/-0.030	25.87	X		T	
39.75	+/-0.030	39.75	X		T	
44.75	+/-0.030	44.75	X		T	
53.51	+/-0.030	53.51	X		T	
63.50	+/-0.030	63.50	X		T	
65.25	+/-0.030	65.25	X		T	
10.75	+/-0.030	10.75	X		T	
11.00	+/-0.030	11.00	X		T	
14.75	+/-0.030	14.75	X		T	
25.50	+/-0.030	25.50	X		T	
25.75	+/-0.030	25.75	X		T	
26.00	+/-0.030	26.00	X		T	
32.87	+/-0.030	32.87	X		T	
38.81	+/-0.030	38.81	X		T	
45.00	+/-0.030	45.00	X		T	
48.25	+/-0.030	48.25	X		T	
58.38	+/-0.030	58.38	X		T	
61.25	+/-0.030	61.25	X		T	
64.13	+/-0.030	64.13	X		T	
64.63	+/-0.030	64.63	X		T	
66.50	+/-0.030	66.50	X		T	
7.50	+/-0.030	7.50	X		T	
9.50	+/-0.030	9.50	X		T	
10.38	+/-0.030	10.38	X		T	
10.88	+/-0.030	10.88	X		T	
14.50	+/-0.030	14.50	X		T	
16.56	+/-0.030	16.56	X		T	
18.75	+/-0.030	18.75	X		T	
24.13	+/-0.030	24.13	X		T	

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	67862
Description: Cabin Floor Protector		Part Number:	D3574-2
Inspection Dwg: D3574	Rev: B	Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
26.50	+/-0.030	26.50	X		T B01	
30.50	+/-0.030	30.50	X			
33.88	+/-0.030	33.88	X			
39.50	+/-0.030	39.50	X			
40.25	+/-0.030	40.25	X			
43.50	+/-0.030	43.50	X			
46.60	+/-0.030	46.60	X			
7.63	+/-0.030	7.63	X			
11.00	+/-0.030	11.00	X			
11.50	+/-0.030	11.50	X			
16.75	+/-0.030	16.75	X			
19.00	+/-0.030	19.00	X			
22.50	+/-0.030	22.50	X			
30.75	+/-0.030	30.75	X			
32.63	+/-0.030	32.63	X			
32.75	+/-0.030	32.75	X			
35.13	+/-0.030	35.13	X			
36.50	+/-0.030	36.50	X			
40.00	+/-0.030	40.00	X			
41.88	+/-0.030	41.88	X			
43.63	+/-0.030	43.63	X			
0.125	+/-0.010	0.133	X		V B02	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-4-4	Date: 11/04/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	
B	08.07.31	47.75 dimension removed	KJ/DD	
C	09.05.15	Dimensions updated per Dwg Rev B	KJ	

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